



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB6873066
Job Sheet 199651



Part No: RB6873066

Job Qty: 2 pcs

Part Name: Compressor Axis Alignment Fixture



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/29/19

Job Tracking No:

Due Date: 11/11/19

Created By: Chantal Lavoie

Type: SOLD

Description:

Note: DWG RB6873066 Rev 2 IPP Rev. A 19.08.28 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	2 pcs	11/11/19	11/11/19	0.00	0.00	Purchasing - 1	ME NOV 07 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	2 pcs	11/11/19	11/11/19	0.00	0.00	Packaging 2 - 1 - B4B	ME NOV 07 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	
							Packaging 2 - 28 - B4B	



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S229929



Part: RB6873066

Job No: 199651

Serial No/Batch: S229929

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 11/07/19

Plex 8/29/19 7:40 AM Dart.Lavoie.Chantal

					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120 QC 6	2 pcs	11/11/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	2 pcs	11/11/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	11/11/19	0.00 0.00		QC 21 - FG - 21	
					QC 21 - FG - 70	
					QC 21 - SA - 53	

DAS

NOV 08 2019

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GA-TBD

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NOV 13 2019

Part Op 100 - (Purchasing) Issue P/O: _____ MANUFACTURE RB6873066 AS PER DWG Supplier: ARROW TECH

Descriptions: Certificate of conformity is required

110 - (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

130 - (Identify as per dwg & Stock Location: _____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
RB6873066P	COMP AXIS ALIGNMENT FIXTURE	2 pcs (1 ea)	100-Purchasing	S229977
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB6873066P	2	0	0
Part Specifications				
Specifications could not be found.				

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PURCHASE ORDER POHB044373



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4998

Attention: Ana
(541) 780-6938

Ship To:

PO No: POHB044373

PO Date: 8/29/19

Due Date: 11/11/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

E-MAILED
AUG 29 2019

Pymt Terms: Net 30

Freight Terms:

Special Comments: QUOTE NO 332

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	199646	RB23033027P			PULLER BRG & MATING SEAL RACE-FRT COMPRESSOR	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$1,835.26/pcs	\$3,670.52
2	199647	RB23033034P			PULLER COMPRESSOR FRONT BEARING OUTER RACE	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$1,344.20/pcs	\$2,688.40
3	199648	RB6895957P			GEARBOX TUBE ALIGN TOOL	Firmed		11/11/19	2 pcs	0 pcs	2 pcs	\$1,264.00/pcs	\$2,528.00
4	199649	RB23006785P			SPUR ADAPTER GEAR INST. TOOL	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$581.00/pcs	\$1,162.00
5	199650	RB6795966P			Compressor Disassembly Fixture	Firmed		11/11/19	2 pcs	0 pcs	2 pcs	\$3,094.45/pcs	\$6,188.90
6	199651	RB6873066P			COMP AXIS ALIGNMENT FIXTURE	Firmed X2		11/11/19	2 pcs	0 pcs	2 pcs	\$3,419.00/pcs	\$6,838.00
7	199652	RB23003267P			Power Turbine Support Cleaning C-18, C-20 & C-28	Firmed		11/11/19	2 pcs	0 pcs	2 pcs	\$2,162.00/pcs	\$4,324.00

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PURCHASE ORDER

POHB044373



Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
8	199653	RB6795590P			Puller-Bearing-Gas Producer & Power Turbine	Firmed	-	11/11/19	2 pcs	0 pcs	2 pcs	\$3,581.00/pcs	\$7,162.00

Grand Total: \$34,561.82

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

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ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No: HB044373

Dated: 11/4/2019

Our Order / Job No: AWT-HB044373 A6

Order Qty: 2

Part Name: COMPRESSOR AXIS ALIGNMENT FIXTURE

Part Number RB6873066

Lot Size: N/A

Ship Date: 11/4/2019

We ~~certify~~ that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RB6873066

Rev: 2

Material Size and Type: -1, -6, -10/ 4140 STEEL; -4/4140 Q&T; -5A, -5B, -5C/ 1018 STEEL;
-12/ MIC 6 ALUM.

Material Specifications: STEEL: ASTM A108; ALUM.: RoHS3 (2015/863 EU) COMPLIANT

Heat Treatment: (-4/28-32 RC); -1/ 31 RC; -6/ 31-32 RC

Plating/Finish: BLACK OXIDE: QMSI-6.2.2 B.O. REV-D; BLACK ANODIZE:MIL-A-8625F,
TYPE II, CLASS II

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 11/4/19

Signed: Herbert M. Fald

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

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